














## Tap M24 Z4

### A10-020

The manufacturing cycle includes the loading and dressing cycle for conventional wheels for flute and thread grinding. After further research in wheel technology the cycle time could be reduced. The thread is dressed with a formroll.



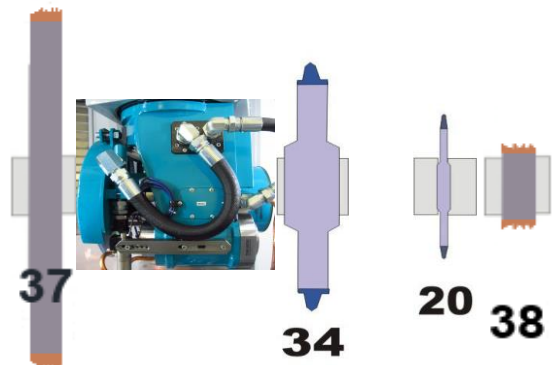
### 1. Cycletime for Production

Tool specifications M24, flutelength 38, Helix 0° Material HSSE							
Operations							
Loading							
Feed [mm/Min]		1000	9000	9000	9000	100	100
Power [kW]		6	4	4	4	1	1
Cutting feed [m/s]		50	65	65	65	24	24
Used wheels							
Grinding time [s]	20	74	38	21	27	21	40
Total cycle time	4 Min 01						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

34 Ø180 DXF A80  
37 Ø400 1A1 A200  
20 Ø125 14EE1 D301  
38 Ø90 DXF D301



### 3. Machine and Software Requirements

Machines: 6 axes CNC grinders : TAP NGM, dressing unit  
Control: Fanuc 31i B5  
Coolant: Synthetic Oil, pressure 9 bar  
Software: Quinto 5.4.6

responsible engineer:

FFR,23.01.15

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